

Work Order ID 69972

Wednesday, May 25, 2011 9:58:14 AM



Page 1

Item ID: D2888

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 5/25/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/2/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

R

Date: 11-05-25 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2888

Rev A2

0.00

100



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blanks at 4.200" long
Grain along 4.200"*

only 11/06/02

10

Ø

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio D2888
Folio Rev: *AA*
Dwg Rev: *A*

A.A 11/06/02

10

Ø

2-Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

B.A 11/06/02

10

0

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

SL 11/06/02

10

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

10

0

SL 11/06/02

Hand Finishing

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Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powder Coating

Memo

START TIME: 9:15

OVEN TEMPERATURE: 320 OF

FINISH TIME: 9:45

0.00

10X ~~✓~~ m.d 11/06/07

160



QC

QC3- Inspect Part Finish

0.00

Quality Control

Memo

0.00

10 ~~✓~~ m.d 11/06/07

170



Packaging

Identify as per dwg & Stock Location: 480

0.00

Packaging

Memo

0.00

11/6/8 ~~✓~~ m.d

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

W/6/8 JG
MF
11-06-08

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Picklist Print

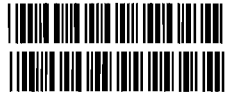
Wednesday, May 25, 2011 9:58:21 AM

Page 1

Work Order ID: 69972

Parent Item: D2888

Parent Item Name: Lug



Start Date: 5/25/2011

Required Date: 6/2/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP C000.06.22 Removed P/O for powder coat EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.500X03.50 0		Purchased	No			100	f	5.5000	0.39	3.9			



6061-T6 Bar 2.50 x 3.50

Location

Loc Qty

Loc Code

MAT008

5.5

113403

5.5

3.9 on 11/06/02

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DART AEROSPACE LTD		Work Order:	69972
Description: Lug		Part Number:	D2888
Inspection Dwg: D2888 Rev: A2		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.386	+0.005/-0.000	Ø0.388	✓		Vern	GA-01
Ø0.88	+/-0.030	Ø0.875	✓		"	"
0.063 x 45°	+/-0.010	0.065 x 45°	✓		"	"
4.06	+/-0.030	4.061	✓		HG	31006
Ø0.760	+0.005/-0.000	Ø0.762	✓		VERN	GA-01
3.48	+/-0.030	3.480	✓		H-G	31006
2.500	+/-0.010	2.500	✓		Vern	GA-01
2.75	+/-0.030	2.745	✓		"	"
0.438	+/-0.010	0.439	✓		"	"
0.080 x 45°	+/-0.010	0.085 x 45°	✓		"	"
1.85	+/-0.030	1.850	✓		"	"
1.000	+/-0.010	1.001	✓		"	"
0.425	+/-0.010	0.425	✓		"	"
0.030 x 45°	+/-0.010	0.027 x 45°	✓		"	"
1.875	+/-0.010	1.874	✓		"	"
0.375	+/-0.010	0.375	✓		"	"
R0.25	+/-0.030	R0.250	✓		R-G	ref.
1.29	+/-0.030	1.288	✓		Vern	GA-01
0.414	+/-0.010	0.414	✓		H-G	31006
3.41	+/-0.030	3.412	✓		Vern	GA-01

Measured by:	B.A	Audited by:	SL	Prototype Approval:	N/A
Date:	11/06/02	Date:	11/06/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.06.04	New Issue	KJ/DD	

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SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

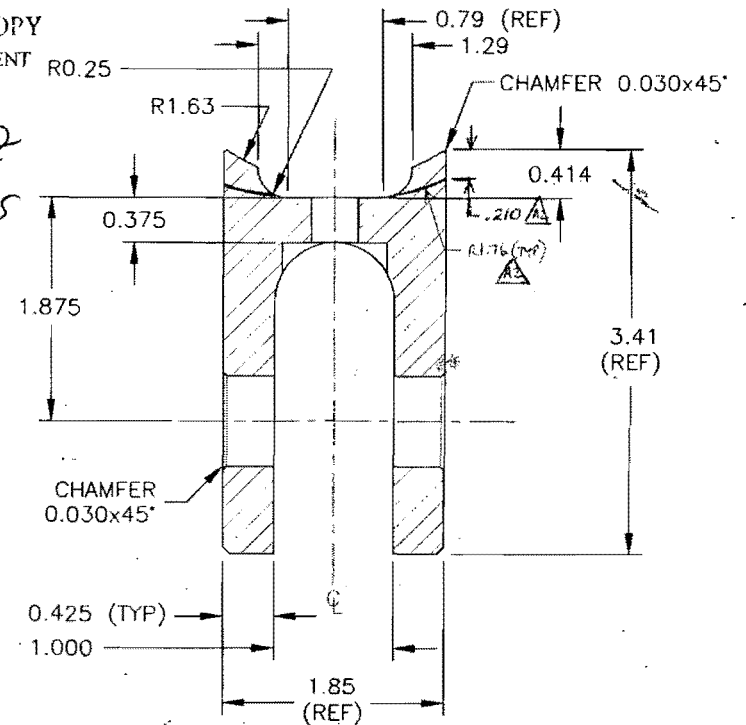
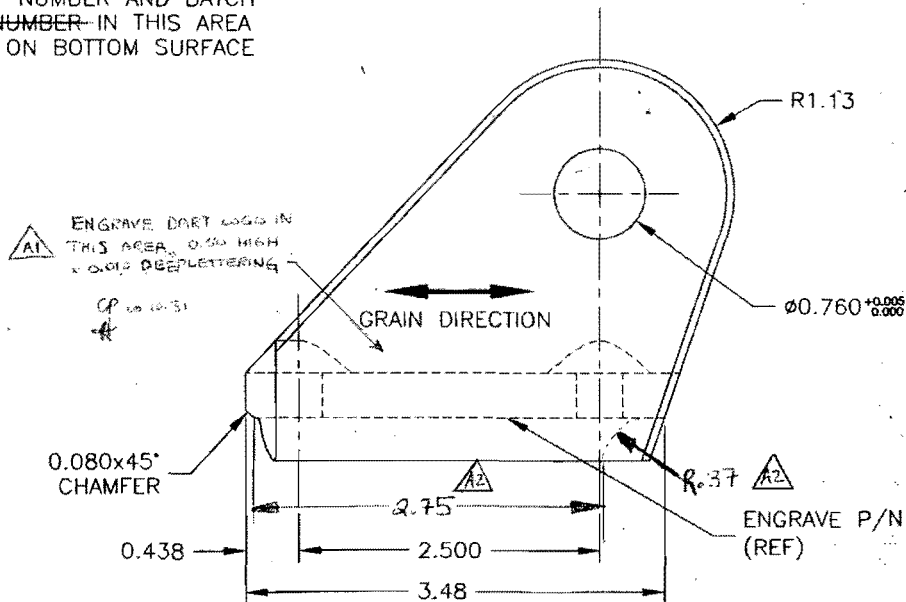
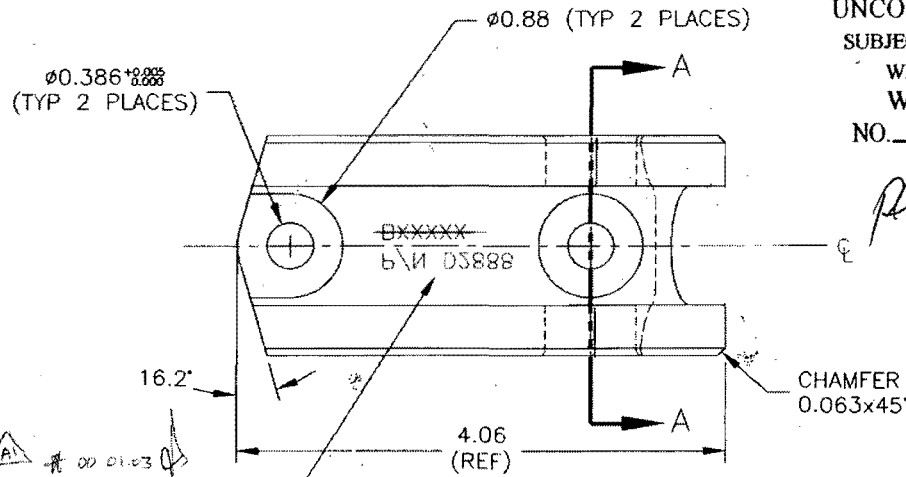
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 69972

11-03-25



SECTION A-A
SCALE 1:1

RELEASED
99.07.09 DS

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
BREAK UNMARKED EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

A2	04.04.08	Add Scribe Clearance
A1	02.10.21	Update Engineering

A	99.06.21	NEW ISSUE
DESIGN	BY	DART
CHECKED	BY	DART
DATE	99.06.21	TITLE
		LUG

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